

# Work Order ID 54142

December 1, 2009 9:24:20 AM



Page 1

Item ID: D3823-2KGY

Accept



Setup Start



Revision ID: C

Stop



Item Name: Overhead Rear, RH-Grey

Start Date: 02/12/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*BP*

Date: 09-12-1

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

03823

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

09/12/09  
X4

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA031 using tool DT9113  
Dwg Rev: C  
Folio Rev: A

09/12/09  
X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 54142

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Page 2

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Required Date: 08/12/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

BB 09/12/16

X4

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 8 09/12/17



140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

BB 09/12/16

X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 54142**

December 1, 2009 9:24:20 AM



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Item ID: D3823-2KGY

Accept



Setup Start



Revision ID: C

Stop



Item Name: Overhead Rear, RH-Grey

Start Date: 02/12/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

BB 09/12/16  
(X4)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 506/12/17

(X4)

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

9/12/17 58 4x

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 54142

December 1, 2009 9:24:20 AM



Page 4

Item ID: D3823-2KGY

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Setup Start



Revision ID: C

Stop



Item Name: Overhead Rear, RH-Grey

Start Date: 02/12/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 08/12/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/17

ME  
09-12-17

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

December 1, 2009 9:24:27 AM

Page 1

Work Order ID: 54142



Parent Item: D3823-2KGYRevC



Parent Item Name: Overhead Rear, RH-Grey

Start Date: 02/12/2009

Required Date: 08/12/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No				sf	652.4508	44.6223			



Kydex steel grey



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

111807

652.4508

652.4508

3B 09/12/09  
X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 54142
<b>Description:</b> Rear Overhead, RH		<b>Part Number:</b> D3823-2KIV/KGY
<b>Inspection Dwg:</b> D3823	<b>Rev:</b> C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/12/16

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5	Min	.55	✓			
0.44	Min	.458	✓			
1.75	Min	1.84	✓			
0.045	Min	.057				
0.055	Min	.065				

Measured by: BB

Date: 09/12/16

Audited by: BB

Date: 09/12/16

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ	

SHOP COPY

RETURN TO:

ENGINEERING

UNCONTROLLED

SUBJECT TO AMEND

WITHOUT NO

WORK OR

NO. 521142

BS 09-12-1

MIN THICKNESS  
0.045  
(SHADED REGION)

14.3  
REF

1.75  
MIN

RELEASED  
9/10/2005

B8-1  
DETAIL B

B6-1

B

0.44  
MIN

A

TEXTURED SIDE

35.94  
REF

C4-1

SECTION A-A

D6-1

DETAIL B  
SCALE 5X

0.5  
MIN

0.9  
REF

0.40  
REF

B

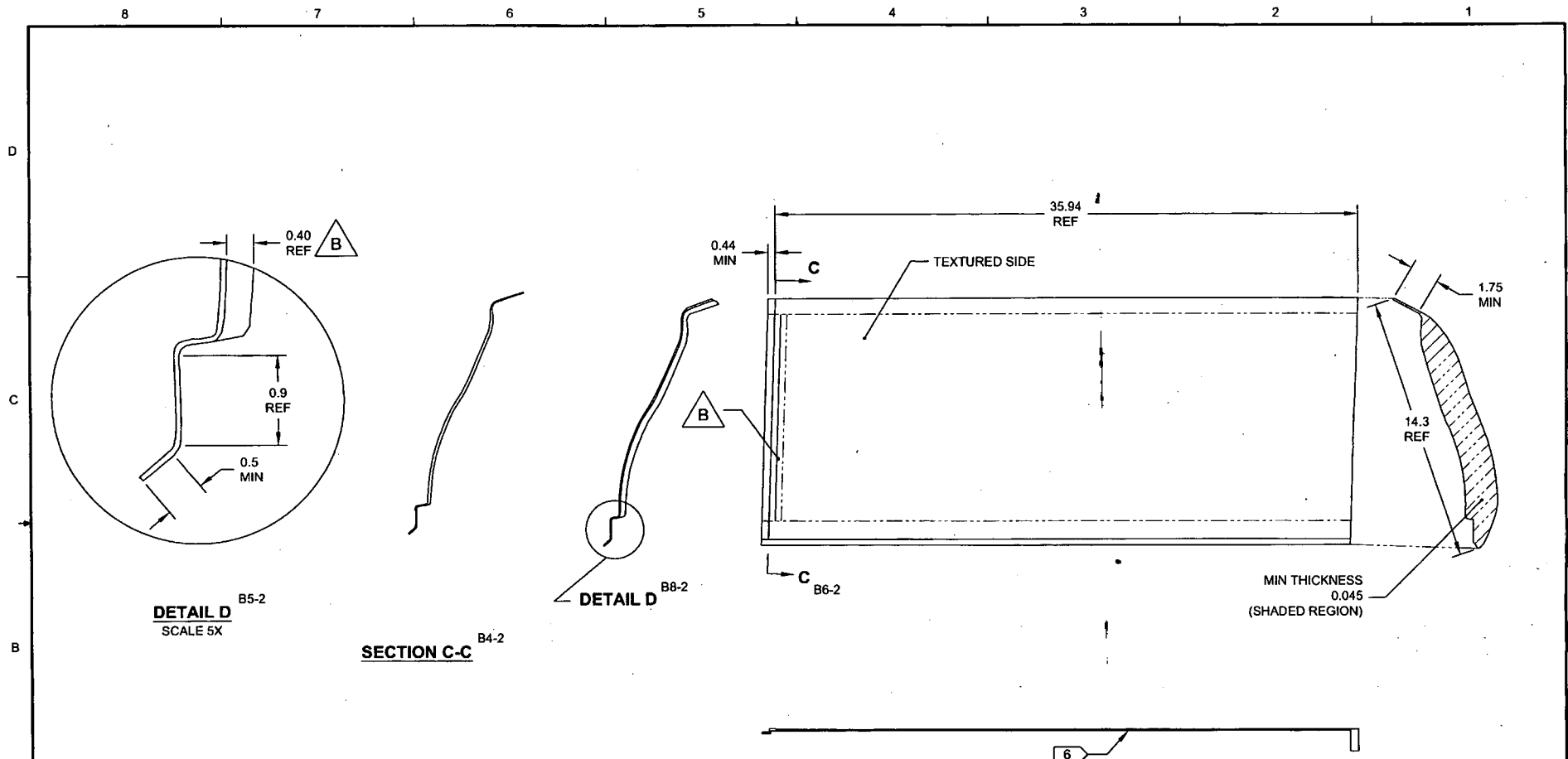
D3823-1 REAR OVERHEAD, LH

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.9 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9112 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3823-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3823-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3823-1/2/3(KIV) AND ADD STEEL GRAY P/N'S D3823-1/2/3(KGY) (ZN A5-1, A5-2, A5-3)	PH	09.05.05
B	ADD JOGGLE TO D3823-1/2/3 FOR BETTER FIT WITH D3824-1/3 HAT BIN (ZN C5-1, C5-2, C8-3); 0.40 WAS 0.18 (ZN B7-1, D7-2); 0.45 WAS 0.29 (ZN B8-3)	PH	09.02.09
A	NEW ISSUE	PH	08.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.05		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.		REV. C	
D3823		SHEET 1 OF 3	
TITLE		SCALE	
REAR OVERHEAD		NTS	
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# **D3823-2 REAR OVERHEAD, RH**

## **NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.9 lbs
- 8) TOOLING: THERMOFORM PER MOLD-DT9113 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

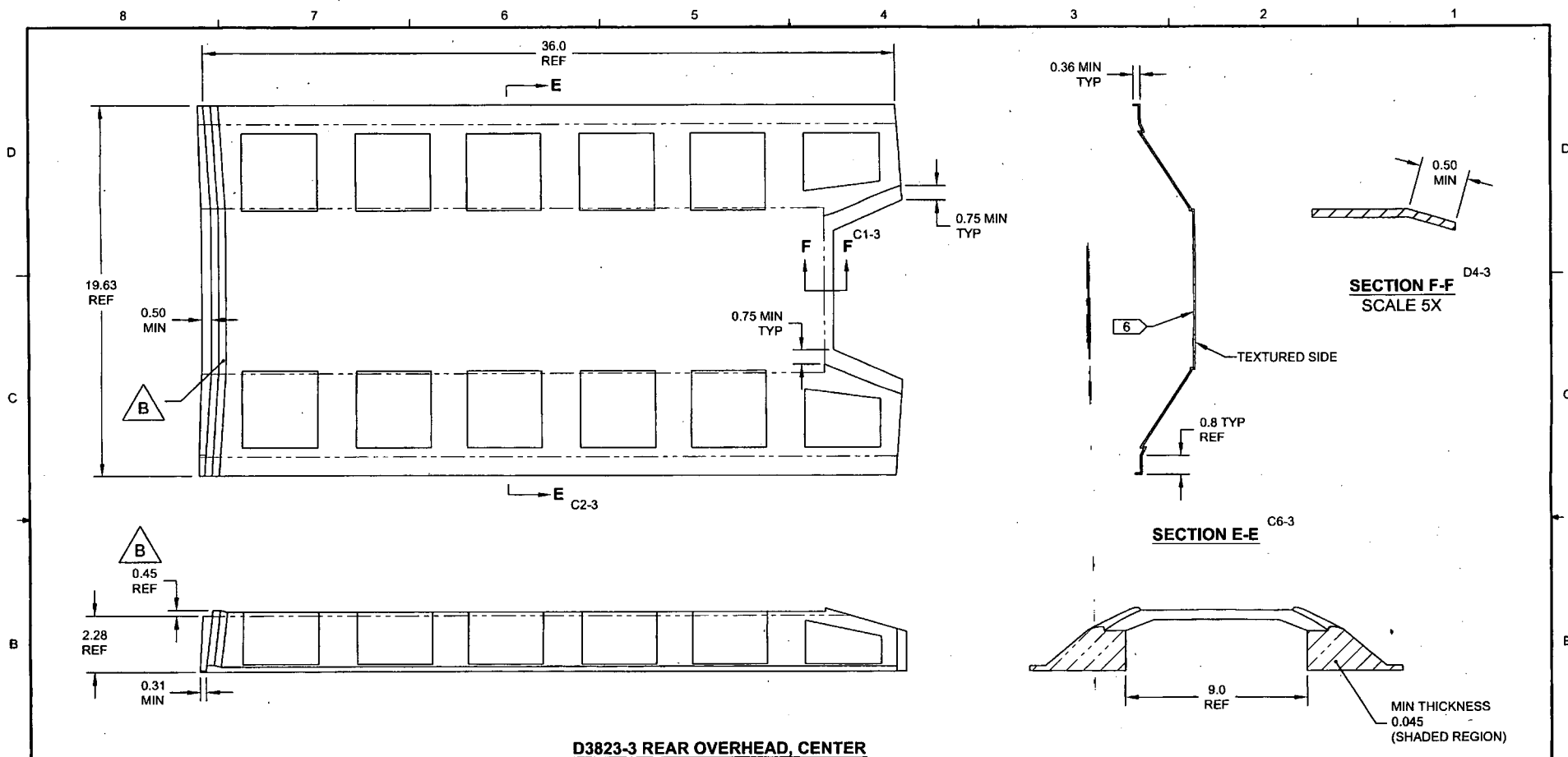
PART NUMBER	DESCRIPTION
D3823-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3823-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3823 SHEET 2 OF 3
APPROVED		TITLE SCALE
DE APPR.		REAR OVERHEAD NTS
DATE	09.05.05	

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**RELEASED**  
09/12/12 MTD

W/0 54142



# NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 2.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9110 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED



PART NUMBER	DESCRIPTION
D3823-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3823-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PA	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	RA	
CHECKED	A	
MFG. APPR.	W/D	
APPROVED	W/D	
DE APPR.	W/D	
DATE	09.05.05	
DRAWING NO.	D3823	REV. C
TITLE	REAR OVERHEAD	SHEET 3 OF 3
		SCALE NTS

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09/05/2005

W/054142